

Work Order ID 66894

Wednesday, March 02, 2011 10:28:16 AM



Page 1

Item ID:	D2232-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Hinge					
Start Date:	3/2/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	3/8/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2232 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								

B11-3-2

(6)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-3-2

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5/11/13

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66894

Wednesday, March 02, 2011 10:28:16 AM



Page 2

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hinge

Start Date: 3/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo Debur	0.00							
Small Fab									
140 Packaging	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo *****STOCK IN BASKET CELL*****	0.00							
150 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

WAS

SAD
11-03-03

(6)

11/03/04

MF
11-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 10:28:29 AM

Page 1

Work Order ID: 66894

Parent Item: D2232-3

Parent Item Name: Basket Hinge




Start Date: 3/2/2011

Required Date: 3/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 01.06.07 Now laser cut EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	38.8800	0.0694	0.438316			

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT

38.88

116623

38.88

116623

6

B11-3-2

W/O:		WORK ORDER CHANGES					
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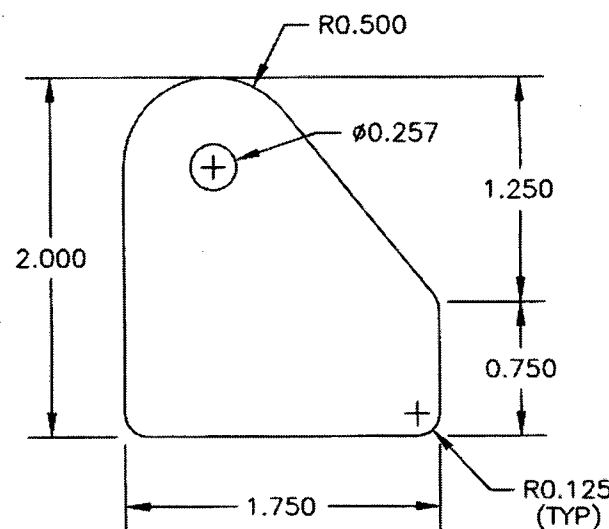
NOTE: Date & initial all entries

DART



RELEASED
98.05.05 KE

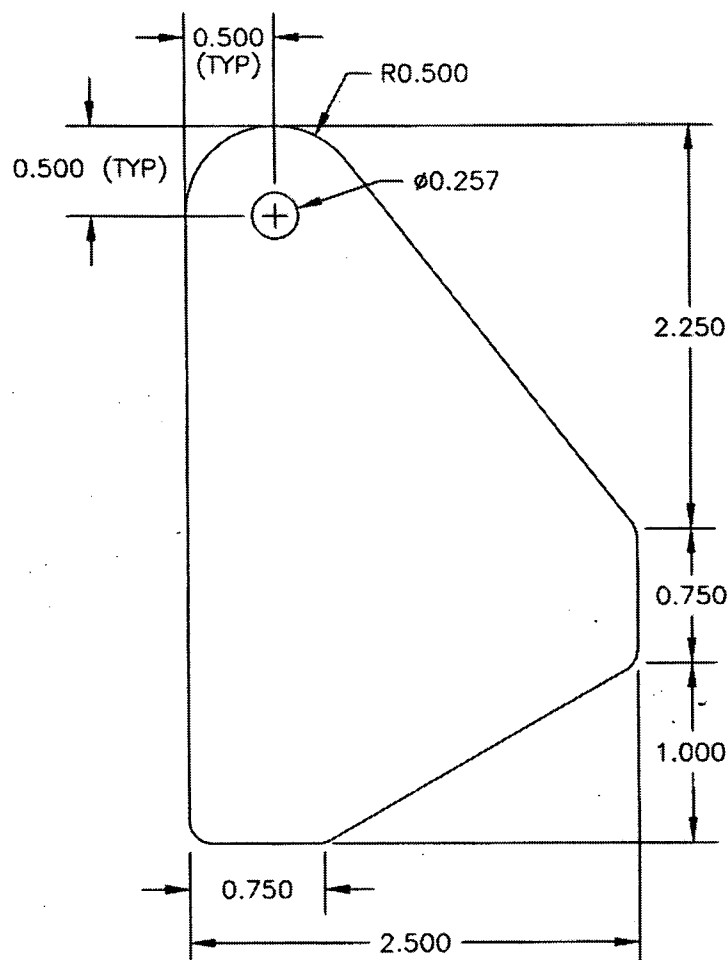
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	



D2232-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66894

PL 11-03-2



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

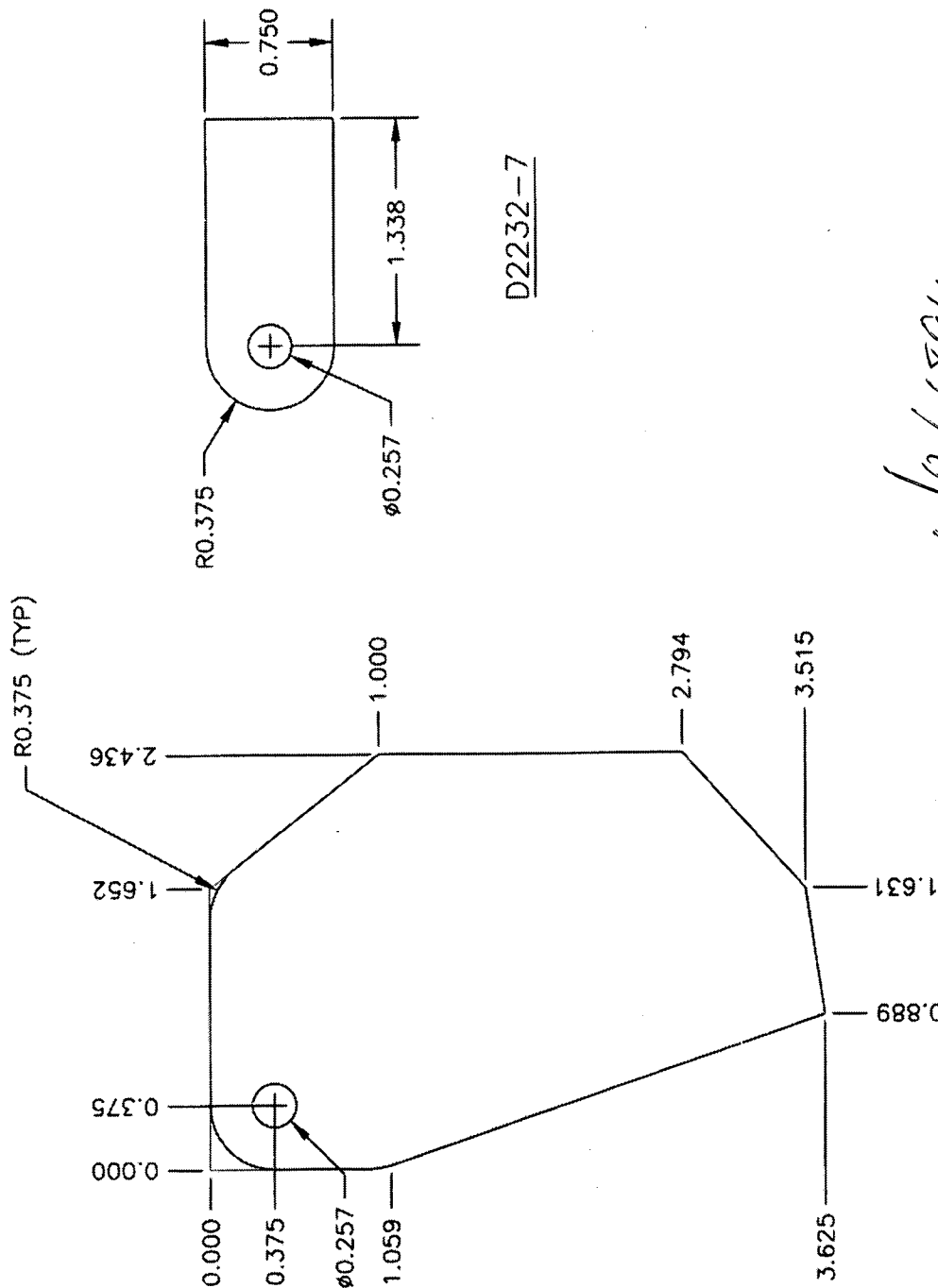
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

w/0 66894

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
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